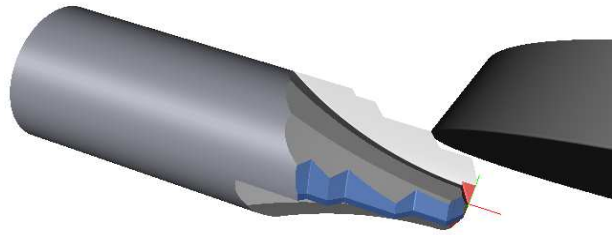








Profiled milling cutter Ø25 Z3

A02-001

This is an example of profiled milling cutter with step profile made out of solid carbide. The indicated time is based on grinding the profile only. It is preground with Periphery of 1A1 wheel, and finished with a cup wheel.



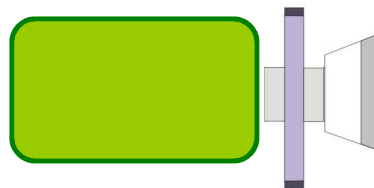
1. Cycletime for Production

Workpiece: Diameter 25 mm, Z 3, Length of cutting edge 30 mm Material CARBIDE				
Operations				
Feed [mm/Min]	2000	50	60	60
Power [kW]		3	1	1
Cutting speed [m/s]		22	22	22
Used wheels				
Grinding time [min]	0.5	3.0	2.5	2.5
Total cycle time	8min 30sec			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	11V9 Ø100 D64



1	2
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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA / ARIES Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 310i Software: Quinto 5
Accessories:
Responsible engineer: SIW. 24.5.13

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